

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015922**Date Inspected:** 28-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

OBG Seg 9BW to Seg 9CW:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9B-007. The welder was identified as 045196 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9CW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SP771-001-011. The welder was identified as 045143 and was observed welding in the 2F position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

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OBG Seg 9DE:

Repair welding on weld joint no: Seg058-049. Welding process was identified as FCAW. The welder was identified as 220066 and was observed welding in the 2G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): WR-14138 Rev-0.

Cross Beam 12 (CB12) and Seg 9DW:

The FCAW process on weld joint no's: BP025-PP81-024 to 043. The welder was identified as 222396 and was observed welding in the 2F position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2132. See attached photo for further details.

The FCAW process on weld joint no's: BP205-012-003 and 004. The welder was identified as 222396 and was observed welding in the 2F position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

Bay 7- CB 18:

The FCAW process on weld joint no's: SP3089-018-007 and 008. The welder was identified as 062447 and was observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: FB4106-018-001 and 002. The welder was identified as 217185 and was observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
